		<b>~</b>			La companya da					
Work Order I										
Item ID: D36. Revision ID: Item Name: Doub			Accept				Setup Start Stop			
<u> </u>	/2010 Start Qty: 8.0			Cust Item I Customer:	<b>D:</b>		<b>F</b>	) 1883/181 Proise (18 118/189)		
Approvals: Pro	cess Plan:	Date:	Tooling: SPC (Y/N):		ate:	] - -	Run Start Stop			
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Draw Number	Draw Plan Rev. Code		•	Reject Insp. Number Stamp		
Draw Nbr	Revision Nbr									
D3639	Rev A									
Waterjet FLOW CNC Waterjet			0.00  0.00  Dwg Rev: A □Prog Rev:	₽ □2-		_B 1	0-6-5	9		
110 QC Quality Control	QC2- Inspect parts o	ff machine FAI/FAIB	0.00	·		(\$)	0-6-2			
120	QC8- Inspect parts -	second check	0.00	1 /.		(29)				

QC

Memo

0.00 & (0/06/02/02.

Quality Control

W/O:			W	ORK ORDER CHANG	iES			<del>1</del>		
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•								
Part No	:	PAR #:	Fault Cate	egory:	_ NCR	:Yes N	lo <b>DQ</b> A	<b>4:</b>	Date:	
		esolution:								
NCR:		V	VORK ORD	ER NON-CONFORM	ANCE	(NCR)	:		,	
DATE	STEP	Description of NC	Corrective Action Section B			Verifica			Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
			,							Į.
		·								
										<u> </u>

# Work Order ID 58830

Wednesday, May 19, 2010 1:07:04 PM



Page 2

Item ID:

D3639-4

Accept

Setup Start

Stop



**Revision ID:** 

Doubler Item Name:

5/19/2010

Start Qty: 8.00

**Required Date: 5/26/2010** 

Req'd Qty: 8.00



Date:

**Cust Item ID: Customer:** 

Draw

Number

Reference:

**Start Date:** 

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

0.00

0.00

Date:

Date:

Run

Reject

Qty

Start

Stop

Reject

Number

Insp.

Stamp

Sequence ID/ Work Center ID

130

Brake NC Brake NC

Operation Description

NC BRAKE

Memo Form as per Dwg D3639 Set Up/ **Run Hours** 

SB 10/06/03

Draw

Rev.

Plan

Code

Qty

Accept

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

150

HandFinish

0.00

Hand Finishing

Memo

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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										į
Part No	•	PAR #:	Fault Cat	tegory:	_ NCR	: Yes N	lo <b>DQ</b>	A:	Date:	
		esolution:								
NCR:				DER NON-CONFORMA					-1	
DATE	CTED	Description of NC		Corrective Action Section	on B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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#### Work Order ID 58830

Wednesday, May 19, 2010 1:07:04 PM



Page 3

Item ID:

D3639-4

Accept

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name: Doubler

5/19/2010

Start Qty: 8.00

Required Date: 5/26/2010

Req'd Qty: 8.00



**Cust Item ID: Customer:** 

Reference:

Δı	provals:	
Y 2	JPI O TAIS.	

Process Plan:

QC:

Date:

Date:

**Tooling: SPC (Y/N):** 

Date: Date: Run

Start Stop



Sequence ID/ Work Center ID

160

Operation Description

**OC3- Inspect Part Finish** 

Memo

Set Up/ **Run Hours** 

0.00

Draw

Number

Draw Rev.

Code

Plan

Reject Accept Qty Qty

Reject Number

Insp. Stamp

Quality Control

170

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

X9 3B 10/06/08.

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

N10-4-08
(9)

	· · · · · · · · · · · · · · · · · · ·								
W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•						
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQ</b>	\:	Date:	
		olution:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	n B Sign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector
			Officer Errig	Ciller Elig	Date				,
	į								
	1 [		1		1	- 1		1	1

#### **Picklist Print**

Wednesday, May 19, 2010 1:07:08 PM

Work Order ID: 58830

Parent Item:

Comments:

D3639-4

Parent Item Name:

Doubler

IPP Rev:A New Issue 07-07-20 JLM

Verified By:EC

**Start Date:** 5/19/2010

Required Date: 5/26/2010

Page 1

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on . Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	33.9947	0.4277	3.8		
2024-T3 .050 sheet		<b>181</b>							(4 m){		10-6-3	

Location	Loc Oty	Loc Code		_
MAT22	33.9947			<i>1</i> 80x
111381	30.9		111381	( )
112291	2.7			
113189	0.3947			

W/O:			WC	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
	Res	olution:	Disposition	n:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approvai
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
								·	
•									

DART AEROSPACE LTD	Work Order:	58830
Description: Doubler	Part Number:	D3639-4
Inspection Dwg: D3639 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.635	4			
Ø0.191	+0.005/-0.001	1192	¥			· · · · · · · · · · · · · · · · · · ·
Ø0.098	+0.004/-0.001	101	4			
0.45	+/-0.030	,453	×			
1.350	+/-0.010	1,356	¥			
2.25	+/-0.030	7.753	*	,		
3.15	+/-0.030	3,157	1			
4.05	+/-0.030	4057	*	,		
4.95	+/-0.030	4.950	×			
5.85	+/-0.030	5,851	×			
6.75	+/-0.030	6,752	7			
7.65	+/-0.030	7,653	K			
8.55	+/-0.030	8.551	*			
9.350	+/-0.010		×			
9.45	+/-0.030		<b>Y</b> -			
10.350	+/-0.010	10,253	Ý			
11.25	+/-0.030	11,36(	k			
12.15	+/-0.030	12.15	7			· · · · · · · · · · · · · · · · · · ·
12.85	+/-0.030	BEND				
13.86	+/-0.030	13,86	<b>Y</b>			
13.96	+/-0.030	13,96	<b>6</b>			
0.805	+/-0.010	,805	<b>b</b>			1
1.00	+/-0.030	1,003	6			
2.100	+/-0.010	२,०११	\$			
3.30	+/-0.030	3,301	4			`
2.000	+/-0.010	1.999	8			
2.590	+/-0.010	7.689	8			

Meas	ured by:	iB.	Audited by:	8	KK P	Prototype Approval:	N/A
	Date:	10-6-2	Date:	106660	14/0/	Date:	N/A
Rev	Date	Change			114/03	Revised by	Approved
A	07.10.24	New Issue				KJ/EC/DD	DY.

W/O:		WORK ORDER CHANGES									
DATE STEF		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			· · · · · · · · · · · · · · · · · · ·								
Part No:		PAR #:	Fault Cate	egory:	_ NCR: Ye	s No I	DQA:	Date:			
Resolution:			Disposition	QA: N/C Closed:			Date:				
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NO	R)	•				
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Verification Control Co		Approval	Approval		
DAIL			Initial Chief Eng	Action Description Chief Eng			Section C	Chief Eng	QC Inspector		
	!	•									
-											

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED CONV 3 2 SUBJECT TO AMENDMENT R0.75 WITHOUT NOTICE 0.710 3.55 3.77 4.00 0.69 1.59 1.69 Ø0.098 THRU 2.49 (9 PLACES) 2.94 3.39 2.590 3.990 8.59 Ø0.625 4.990 2.000 5.19 **GRAIN** DIRECTION Ø0.191 6.99 R0.19 (4 PLACES) 7.49 19° 8.64 (REF) BEND LINE D3639-1 DOUBLER R0.25 (TYP) (WAS GENEVA P/N G10604-3) D3639-2 OPPOSITE **D3639-1F FLAT PATTERN** (WAS GENEVA P/N G10604-6) (D3639-2F OPPOSITE) NEW ISSUE; REPLACES G10604 07.07.27 REV. DESCRIPTION BY DATE NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S.050)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.14 lbs DESIGN DART AEROSPACE USA, INC. DRAWN PORT HADLOCK, WA CHECKED DRAWING NO. REV. A D3639 MFG. APPR. SHEET 1 OF 2 APPROVED TITLE SCALE **DOUBLER** DE APPR

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07.07.27

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W/O:			W	ORK ORDER CHANG	ES				
DATE STEP		PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No: PAR #:		PAR #:	Fault Category: NCR: Yes No DQA:				.: Date:		
		Dispositio	n:	_ QA: N/C Clo	osed:	Date:			
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR	3)			
DATE	STEP	Description of NC Section A	Corrective Action Section			Verification	Approval	Approval	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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3 R0.25 00 (4 PLACES) 0.45 1.350 2.25 3.15 GRAIN DIRECTION 4.05 4.95 Ø0.098 THRU (TYP) 5.85 6.75 13.90 7.65 8.55 -Ø0.625 9.350 9.45 10.350 2.000 11.25 2.590 12.15 -R0.19 -Ø0.191 12.85 (4 PLACES) 13.86 ~ 13.96 19° BEND LINE R0.03 (REF) (4 PLACES) D3639-3 DOUBLER 2.100 8. 3.30 (WAS GENEVA P/N G10604-4) D3639-4 OPPOSITE (WAS GENEVA P/N G10604-5) wlo 58830 **D3639-3F FLAT PATTERN** (D3639-4F OPPOSITE) NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S.050)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.3 lbs DART AEROSPACE USA, INC.
PORT HADLOCK, WA DESIGN DRAWN CHECKED DRAWING NO. REV. A D3639 MFG. APPR. SHEET 2 OF 2 TITLE **APPROVED** SCALE **DOUBLER** DE APPR. COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	CEDURE CHA	NGE		By Date Qty Approva			Approval Chief Eng / Prod Mar	Approval QC Inspector		
					-							
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Part No:		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:							
							osed: Date:					
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)	)					
DATE	0750	Description of NC	Corrective Action Section B			Varif		ation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector		
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